



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

646.3015

Job Sheet 174112



Part No: 646.3015

Job Qty: 6 ea

Part Name: Blade



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/9/18

Job Tracking No:

Due Date: 3/19/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG REV N/C SHEET 12 IPP REV:A NEW ISSUE 12/11/09 JFS VERIFY BY: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea	3/10/18		0.00	0.00	Start Up Machining-1		
100	Bandsaw	6 pcs	3/10/18		0.00	0.09	Bandsaw1		DAS
110	CNC Vertical Machining	6 pcs	3/12/18		0.18	7.53	HAAS1-1		54
120	QC	6 pcs	3/12/18		0.00	0.00	QC2 Machining-1		9-89
130	QC	6 pcs	3/12/18		0.00	0.00	QC8 Machining-1		B-A 18-05-08
140	Outsource	6 pcs	3/17/18				MEI001-VC AIT	5	18-05-15
150	Packaging	6 pcs	3/17/18		0.00	0.00	Packaging2		AP 18-05-22
155	QC	6 pcs	3/17/18		0.00	0.00	QC5		10-15-22
160	SprayPaint	6 pcs	3/19/18		0.00	0.19	Spray Paint	DAS	ADAM 18-05-22
170	QC	6 pcs	3/19/18		0.00	0.00	QC14	6	11 MAY 24 2018
180	Packaging	6 pcs	3/19/18		0.00	0.00	Packaging3-1	9-89	9-89 MAY 24 2018
190	QC21-SA	6 Ea	3/19/18		0.00	0.00	QC21		DAS 21 9-89 MAY 24 2018

Part Op 100 - Cut Blank at 6.580"

Descriptions: 110 - 1-Machine per folio FB150

140 - FINISH: HEAT TREAT TO 58-62 RC ROCKWELL HARDNESS As per dwg 646.3000 PART ARE MADE FROM AISI

A2 TOOL STEEL DETAIL OF C OF C REQUIRED

160 - PRIME AS PER DWG, SEE NOTE #4 138408

180 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MSTEEL-A2-B0.500X1.250	AISI A2 Tool Steel Bar, 0.500 X 1.250	3.2940 ft (.549 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MSTEEL-A2-B0.500X1.250	3	112	0

DART
AEROSPACE

1474 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S068686



Part: 646.3015

Job No: 174112

Serial No/Batch: S068686

Revision:

Inspector:

Date: 05/05/10

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Blade	0.375inches $\pm$ 0.005	0.380 0.370		
2	Blade	0.177inches $\pm$ 0.005 - 0.000	0.182 0.177	Diameter	
3	Blade	0.940inches $\pm$ 0.010	0.950 0.930		
4	Blade	0.524inches $\pm$ 0.005	0.529 0.519		
5	Blade	0.240inches $\pm$ 0.020	0.260 0.220		
6	Blade	0.125inches $\pm$ 0.005	0.130 0.120	Radius	
7	Blade	45.000Degrees $\pm$ 0.500	45.500 44.500		
8	Blade	0.524inches $\pm$ 0.005	0.529 0.519		
9	Blade	0.690inches $\pm$ 0.002	0.692 0.688		
10	Blade	1.250inches $\pm$ 0.002	1.252 1.248		
11	Blade	4.684inches $\pm$ 0.005	4.689 4.679		
12	Blade	6.450inches $\pm$ 0.010	6.460 6.440		
13	Blade	0.325inches $\pm$ 0.005	0.330 0.320		
14	Blade	30.000Degrees $\pm$ 0.500	30.500 29.500		

Plex 3/9/18 4:26 PM Dart.Gagnon.Michelle



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO039907**

Supplier: ATL002-VC
Atlantic Heat Treat 2001
401 Frankcom
Ajax
ON
L1S R14 Canada
Phone: 866 257 6395

PO No: PO039907
PO Date: 5/15/18
Due Date: 5/22/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	174112	646.3015	Blade FINISH: HEAT TREAT TO 58-62 RC ROCKWELL HARDNESS As per dwg 646.3000 PART ARE MADE FROM AISI A2 TOOL STEEL DETAIL OF C OF C REQUIRED	Firmed	5/22/18	20 pcs	0 pcs	20 pcs	\$3.75/pcs	\$75.00
						✓ 20x			AT 12/05/18	
2	175728	C45-13-1	Keeper Bushing 1--Issue P/O to Atlantic Heat Treat; P/O _____ RC 44-46 2-Bead blast 3- Certificate of Conformity is required ***NOTE*** DROP SHIP TO FINISHER Atlantic Heat Treat to ship directly to Groupe Altech*** Material 4140	Firmed	5/22/18	21 pcs	0 pcs	21 pcs	\$3.57142857/pcs	\$75.00
Grand Total:										\$150.00

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 5/22/18 11:28 AM dart.tsimiklis.chrisoula

CE.

Certification

Date: 05/17/2018

Entry Date: 05/17/2018

Page: 1 of 1

To:DART AEROSPACE LTD.
1270 ABERDEEN ST

Purchase Order No.: po039907

Packing List No.:

HAWKESBURY ON K6A 1K7

Material: 4140

We are pleased to provide you with the following Certificate of Compliance.

Quantity	Part Number / Part Name / Part Description	Pounds
20	20 pcs material A2 harden 58-62 rc C OF C PART# 6463015	14

Insp. Type	Scale	Minimum	Maximum	Number	Other
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Customer Requirements:

RC rockwell

DAS
9
9-89**Results:**

Harden ROCKWE 58. 62. 62. TESTED AS PER SAMPLING PLAN

HEAT TREATED TO 62 RC AS PER CUSTOMER REQUEST

STATEMENT OF LIMITED LIABILITY (PLEASE READ CAREFULLY). ALL WORK IS ACCEPTED SUBJECT TO THE FOLLOWING CONDITIONS: It is recognized that even after employing all the scientific methods known to us, hazards still remain in metal treating. THEREFORE, OUR LIABILITY SHALL NOT EXCEED TWICE THE AMOUNT OF OUR CHARGES FOR THE WORK DONE ON ANY MATERIAL (FIRST TO REIMBURSE FOR THE CHARGES AND SECOND TO COMPENSATE IN THE AMOUNT OF THE CHARGES), EXCEPT BY WRITTEN AGREEMENT SIGNED BY THE METAL TREATER. THE CUSTOMER, BY CONTRACTING FOR METAL TREATMENT, AGREES TO ACCEPT THE LIMITS OF LIABILITY AS EXPRESSED IN THIS STATEMENT TO THE EXCLUSION OF ANY AND ALL PROVISIONS AS TO LIABILITY ON THE CUSTOMER'S OWN INVOICES, PURCHASE ORDERS OR OTHER DOCUMENTS. IF THE CUSTOMER DESIRES HIS OWN PROVISIONS AS TO LIABILITY TO REMAIN IN FORCE AND EFFECT, THIS MUST BE AGREED TO IN WRITING, SIGNED BY AN OFFICER OF THE TREATER, IN SUCH EVENT, A DIFFERENT CHARGE FOR OUR SERVICES REFLECTING THE HIGHER RISK TO TREATER, SHALL BE DETERMINED BY THE TREATER AND CUSTOMER. THE TREATER MAKES NO EXPRESS OR IMPLIED WARRANTIES AND SPECIFICALLY DISCLAIMS ANY IMPLIED WARRANTY OF THE FITNESS FOR A PARTICULAR PURPOSE OR MERCHANTABILITY, AS TO THE PERFORMANCE OF CAPABILITIES OF THE MATERIAL AS HEAT TREATED, OR THE HEAT TREATMENT. THE AFOREMENTIONED LIMITATION OF LIABILITY STATED ABOVE IS SPECIFICALLY IN LIEU OF ANY EXPRESS OR IMPLIED WARRANTY, INCLUDING ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS, AND OF ANY OTHER SUCH OBLIGATION ON THE PART OF THE TREATER. No claim for shortage in weight or count will be entertained unless presented within five (5) working days after receipt of materials by customer. No claim will be allowed for shrinkage, expansion, deformity, or rupture of material in treating or straightening, except by prior written agreement, as above, nor in any case for rupture caused by or occurring during subsequent grinding. Whenever we are given material with detailed instructions as to treatment, our responsibility shall end with the carrying out of those instructions. Failure by a customer to indicate plainly and correctly the kind of material (i.e., proper alloy designation) to be treated, shall cause an extra charge to be made to cover any additional expense incurred as a result thereof, but shall not change the limitation of liability stated above. Customer agrees there will be no liability on the treater in contract for any special, indirect or consequential damages arising whatsoever, including but not limited to personal injury, property damage, loss of profits, loss of production, recall or any other losses, expenses or liabilities allegedly occasioned by the work performed on the part of the treater. It shall be the duty of the customer to inspect the merchandise immediately upon its return, and in any event claims must be reported prior to the time that any further processing, assembling or any other work undertaken. OUR LIABILITY TO OUR CUSTOMERS SHALL CEASE ONCE ANY FURTHER PROCESSING, ASSEMBLING OR ANY OTHER WORK HAS BEEN UNDERTAKEN ON SAID MATERIAL. No agent or representative is authorized to alter the above conditions, except by writing duly signed by an officer of treater.


KEAN SHEPHERD
QUALITY CONTROL
ATLANTIC HEAT TREATING 2001 LTD